

Work Order ID 60457

Friday, July 09, 2010 9:54:58 AM

Page 1

Item ID: D3763-044

Accept

Setup Start

Revision ID:

Stop

Item Name: End Fitting Assembly, RH

Start Date: 7/12/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

MF

Date: 10-7-9

Tooling:

Date:




QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3763	Rev B								
100	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									
110	Large Fab	0.00							
									
Large Fab	Memo	0.00							
Large Fab	1-make a 0.063" chamfer on D3763-1 fitting before ass'y□2-assemble and tack weld as per dwg D3763 using locating pin DT9039□ *****look at dwg before assembling parts (RH) *****□ *****remove pin before welding*****□3-weld as per dwg D3763, QSI004□ Alum								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									

EL 10-8-5

EL 10-8-5 (x4)

H D BE 10/08/05

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60457

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Item ID: D3763-044

Accept

Revision ID:

Item Name: End Fitting Assembly, RH

Start Date: 7/12/2010 Start Qty: 4.00

Required Date: 7/20/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

8/10/05

(74)

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

JH 10/08/05

x v s

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

H BR 10-8-5.

QC

Memo

0.00

Quality Control

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60457

Friday, July 09, 2010 9:54:58 AM



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Item ID: D3763-044

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly, RH

Start Date: 7/12/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location

251A

0.00



Packaging

Memo

0.00

Packaging

10/8/6 sf (40)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/09 J

MF

10-8-6

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 09, 2010 9:54:57 AM

Page 1

Work Order ID: 60457



Parent Item: D3763-044



Parent Item Name: End Fitting Assembly, RH

Start Date: 7/12/2010

Required Date: 7/20/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC
IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3763-1

Manufactured No

110

Each

5.0000

2

8



End Fitting



EL 10-8-4

B60499 x 7

Location

Loc Qty

Loc Code

WA

5

56755

5

D3763-6

Manufactured No

110

Each

34.0000

1

4



Tube



EL 10-8-4

Location

Loc Qty

Loc Code

ST251A

34

42735

24

54798

10

4

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

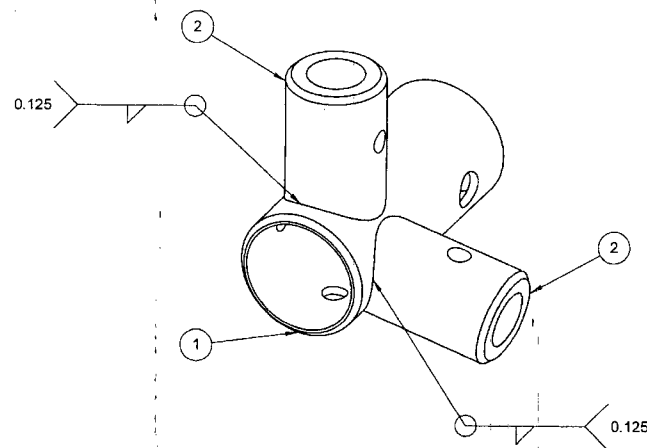
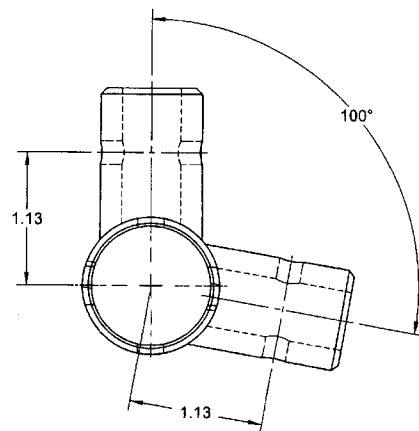
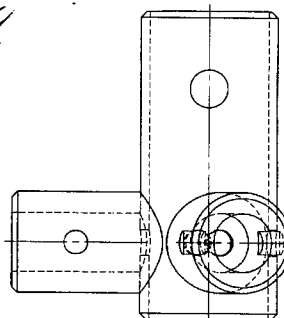
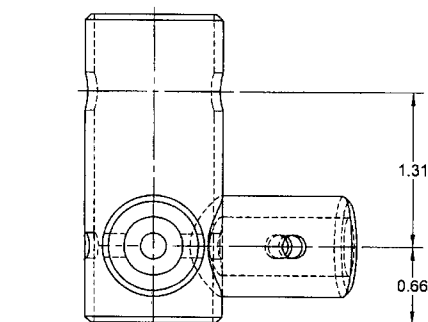
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60457



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

D3763-044 END FITTING ASSY, RH

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs
 - 8) WELD: PER DART QSI 004

RELEASED
08-07-10

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	AS	DRAWING NO. D3763	REV. B
MFG. APPR.	AS	SHEET 3 OF 9	
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	END FITTING	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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